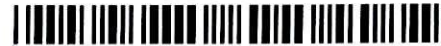




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.2114
Job Sheet 173035



Part No: 647.2114

Job Qty: 10 ea

Part Name: Upper U Channel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/15/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 16/05/13 JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		2/28/18	0.00	0.00	Start Up Machining-1		18-02-26
100	Bandsaw	10 pcs		2/28/18	0.00	0.00	Bandsaw1		18-02-26
105	CNC Vertical Machining	10 pcs		3/1/18	0.00	10.35	HAAS 5 Axis		18-02-26
110	QC	10 pcs		3/1/18	0.00	0.00	QC1		18-02-26
117	QC	10 pcs		3/1/18	0.00	0.00	QC8 Machining-1		18/02/27
120	Outsource	10 pcs		3/15/18			ATG001-VC	10	APAS 18/03/26
130	Packaging	10 pcs		3/15/18	0.00	0.00	Packaging2		APAS 18/03/26
140	QC	10 pcs		3/15/18	0.00	0.00	QC5		11 MAR 27 2018
170	Packaging	10 pcs		3/15/18	0.00	0.00	Packaging3-1		9-00 MAR 28 2018
190	QC21-SA	10 Ea		3/15/18	0.00	0.00	QC21		DAS 21 9-00 MAR 28 2018

Part Op 100 - CUT AT 22.000" LONG

Descriptions: 105 - 1-Machine per folio FB476

110 - Inspect on CMM as per folio CMMA038.

120 - Issue P/O to ATG : 039182 1- Anodize as per MPP-172 sect. 2.1 2- Pretreatment as per MPP-172 sect. 3.3

3-Prime as per MPP-172 sect. 4.3 As Per Dwg 647.2100 Rev. E

170 - Identify as per MPP-120

MAR 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.750X2.250	7075-T6 Sheet 1.750" X 2.250"	18.3400 ft (1.834 ea)	90-Start up Operation	

S044939

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.750X2.250	18	32	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
		 Container No: 8045154 Part: 647.2114 Job No: 173035 Serial No/Batch: 8045154 Revision: 647.2100 Inspector: Date: 02/26/18		Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : _____			

DART AEROSPACE LTD		Work Order: 169382
Description: Mounting Rail		Part Number: 647.2114
Inspection Dwg: 647.2100 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
45.4°	+/- .5°	45.4°	✓		Protractor	
.20	+/- .010	.197	✓		SLIO	Vern
.92	+/- .010	.923	✓		"	
1.32	+/- .010	1.318	✓		"	
R.06	+/- .010	.062	✓		Rad gauge	
.63	+/- .010	.626	✓		SLIO	Vern
3.50	+/- .010	3.500	✓		Height gauge	
21.74	+/- .010	21.740	✓		"	
Ø.201	+ .005/- .001	.203	✓		SLIO	Vern
.39 X 100°	+/- .010 X +/- .5°	.391 X 100	✓		"	
16.0°	+/- .5°	16°	✓		Protractor	
R175.00	+/- .010	175.000	✓		Rad gauge	
Ø.20	+ .005/- .001	.203	✓		SLIO	Vern
.20	+/- .010	.201	✓		"	
3.193	+/- .002	3.193	✓		Height gauge	
4.216	+/- .002	4.216	✓		"	
5.240	+/- .002	5.240	✓		"	
6.420	+/- .002	6.420	✓		"	
7.601	+/- .002	7.601	✓		"	

Measured by: DAS 20 9-89		Audited by: [Signature]	Preliminary Approval:
Date: 18-02-25		Date: 18/02/27	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039182

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039182

PO Date: 3/2/18

Due Date: 3/16/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
MAR 14 2018

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

				Items						
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170833	D5501-3	Body, Lower Cutter, Short Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL- P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** As Per Dwg D5501 Rev. A7 Certification of Conformity is required	Firmed	3/26/18	6 pcs	0 pcs	6 pcs	\$16.33/pcs	\$97.98
2	170453	646.3210	Support Issue P/O to ATG: _____ 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	3/26/18	12 pcs	0 pcs	12 pcs	\$15.18/pcs	\$182.16
3	171981	646.3312	Center Plate Issue P/O to ATG: _____ Hard Anodize Color Black, Prime as per Dwg 646.3300 Rev. N/C	Firmed	3/26/18	20 pcs	0 pcs	20 pcs	\$12.88/pcs	\$257.60
4	170464	646.3610	Filler Issue P/O to ATG: _____ 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	3/26/18	12 pcs	0 pcs	12 pcs	\$7.43/pcs	\$89.16
5	170466	646.3711	Clip Issue P/O to ATG: _____ Hard Black Anodize and Prime as per Dwg 646.3700 Rev. A	Firmed	3/26/18	21 pcs	0 pcs	21 pcs	\$6.93/pcs	\$145.53
6	170467	646.3712	Clip Issue P/O to ATG: _____ Hard Anodize, Color Black and Prime as Per Dwg 646.3712 Rev. A	Firmed	3/26/18	19 pcs	0 pcs	19 pcs	\$6.93/pcs	\$131.67
7	170468	646.3713	Gusset Issue P/O to ATG: _____ Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed	3/26/18	21 pcs	0 pcs	21 pcs	\$16.58/pcs	\$348.18

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3/14/2018

PURCHASE ORDER

Line Item	Job	Part	Description	Items					Unit Price (CAD)	Extended Price
				Status	Due Date	Order Quantity	Received Quantity	Balance		
8	170469	646.3714	Gusset Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.3700 Rev. A	Firmed	3/26/18	21 pcs	0 pcs	21 pcs	\$16.58/pcs	\$348.18
9	173035	647.2114	Upper U Channel Issue P/O to ATG : _____ 1- Anodize as per MPP-172 sect. 2.1 2- Pretreatment as per MPP-172 sect. 3.3 3-Prime as per MPP-172 sect. 4.3 As Per Dwg 647.2100 Rev. E	Firmed	3/26/18	10 pcs	0 pcs	10 pcs	\$12.08/pcs	\$120.80
10	172472	647.7820	Cross Bracket Aft Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O TO ATG : _____ Anodize & prime as per Dwg. 647.7800	Firmed	3/26/18	1 pcs	0 pcs	1 pcs	\$12.08/pcs	\$12.08
11	171212	647.7911	Bracket Issue P/O to ATG : _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N as per Dwg 647.7900 Certification of Conformity is required	Firmed	3/26/18	9 pcs	0 pcs	9 pcs	\$7.73/pcs	\$69.57
12	171380	RBE350A93-3302-02-1	Handle -Issue P/O to ATG : _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3302-02-1 Rev. 11 -Certificate of Conformity is required	Firmed	3/16/18	6 pcs	0 pcs	6 pcs	\$6.08/pcs	\$36.48
13	170577	RBE350A93-3500-00-1	Body -Issue P/O to ATG : _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant as per Dwg RBE350A93-3500-00-1 Rev. 3A -Certificate of Conformity is required	Firmed	3/16/18	6 pcs	0 pcs	6 pcs	\$5.51/pcs	\$33.06
14	171139	RBE350A93-3501-20	Extraction Tool, Hydraulic Pump Pulley Bearing -Issue P/O to ATG : _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3501-20 Rev. E -Certificate of Conformity is required	Firmed	3/19/18	20 pcs	0 pcs	20 pcs	\$5.51/pcs	\$110.20
15	170701	RBT112800-1	Base -Issue P/O to ATG : _____ ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL As per Dwg RBT112800 Rev. 3A -Certificate of Conformity is required	Firmed	3/19/18	6 pcs	0 pcs	6 pcs	\$5.51/pcs	\$33.06

DAS
11
9-89

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3/14/2018

PURCHASE ORDER

				Items						
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
16	171571	SWA6A-800A	Connector Bushing - Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL As Per Dwg SWA6A800 Rev. 4 - Certificate of Conformity is required	Firmed	3/19/18	20 pcs	0 pcs	20 pcs	\$7.33/pcs	\$146.60
									Grand Total: \$2,162.31	

20x At 18/3/16

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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U



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914802

Date: 22-Mar-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
(21) ea	Part: 646.3713 Gusset Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22637	Rev: A PO: PO039182	Line: 7
(21) ea	Part: 646.3714 Gusset Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22638	Rev: A PO: PO039182	Line: 8
(10) ea	Part: 647.2114 Upper U Channel Anodize as per MPP-172 sect. 2.1 2 -Pretreatment as per MPP-172 sect 3.3 3-Prime as per MPP-172 sect 4.3 Job: 22639	Rev: E PO: PO039182	Line: 9
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>22/03/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada			